









Work Order ID 60238

Tuesday, June 29, 2010 11:49:19 AM




Page 1

Item ID: D4004-5 Accept  Setup Start 
Revision ID: Stop 
Item Name: Bottom Strap Attach Bracket
Start Date: 6/29/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 7/6/2010 Req'd Qty: 2.00  Customer:
Reference:


Approvals: Process Plan:  Date: 10/6/29 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4004	A

100  0.00
BAND SAW
Bandsaw Memo 0.00
Jeaspa Bandsaw 1-Cut D3033-144 extrusion to length per D4004-5 detail of dwg D3033
Ensure cut is started at correct place per dwg
Batch: 30209
2-Deburr

GS 0/08/25 (2)

105  0.00
Small Fab Memo 0.00
Small Fab Drill and c/sink holes as per dwg and trim part to length as required.

GS 0/08/25 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60238

Tuesday, June 29, 2010 11:49:19 AM



Page 2

Item ID: D4004-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bottom Strap Attach Bracket

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5/10/08/25

x2

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

J 10/08/25

x2 0

Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10 08 25 (2)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Tuesday, June 29, 2010 11:49:19 AM



Page 3

Item ID: D4004-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bottom Strap Attach Bracket

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>110</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
150	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10/8/25 (208)

10/08/26

mf
10-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 11:49:23 AM

Work Order ID: 60238



Parent Item: D4004-5



Parent Item Name: Bottom Strap Attach Bracket

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD
10.05.17 as per ECN10-562 DD verf:EC
IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3033-144

Manufactured

No

100

f

33.7633

0.41

0.863158



Seat Track



Location

Loc Qty

Loc Code

ST492

33.7633

30209

3.7633

58045

30

Handwritten signature and date: 6/30/08/25

0.863158

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

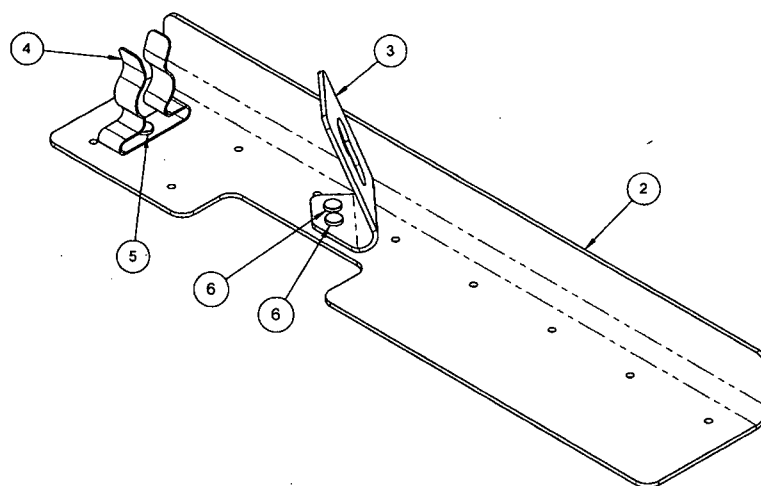
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	STRUT LOCK BRACKET	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	
6	2	MS20426AD4-5	RIVET	



D4004-041 SIDE RESTRAINT ANGLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *60235*
BS10-6-29

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.21 lbs

A	NEW ISSUE		10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JE</i>		
DRAWN	<i>JE</i>		
CHECKED	<i>JE</i>		
MFG. APPR.	<i>JE</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	10.02.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D4004	SHEET 1 OF 11
TITLE SIDE RESTRAINT	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

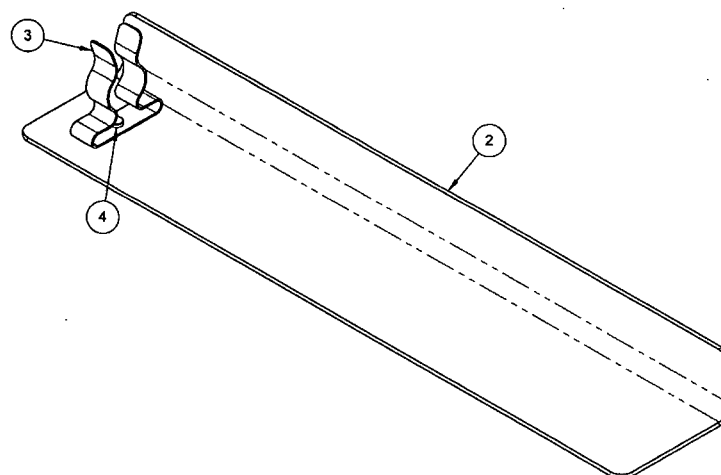
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-043	SIDE RESTRAINT ANGLE AND TIE DOWN POINT	JCA-M47-2-04
2	1	D4004-9	ANGLE	
3	1	D4004-7	HOSE CLIP	
4	1	MS20426AD4	RIVET	



D4004-043 SIDE RESTRAINT ANGLE AND TIE DOWN POINT

w/o 66235

RELEASED
2010-05-05
ND

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4004	REV. A
MFG. APPR.			SHEET 2 OF 11
APPROVED		TITLE SIDE RESTRAINT	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

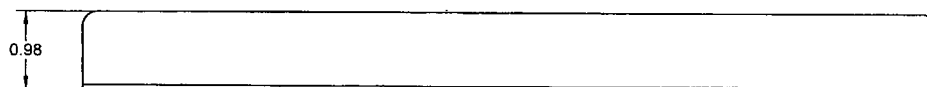
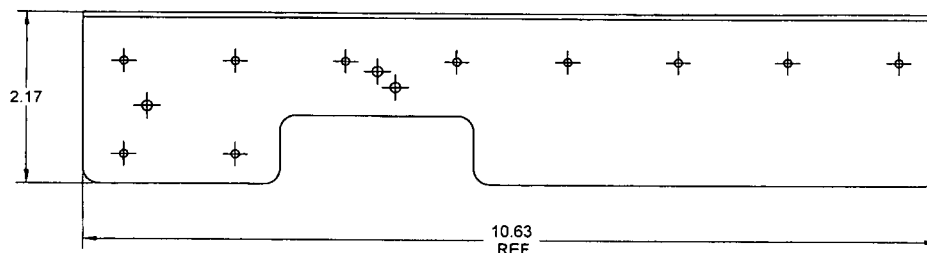
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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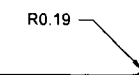
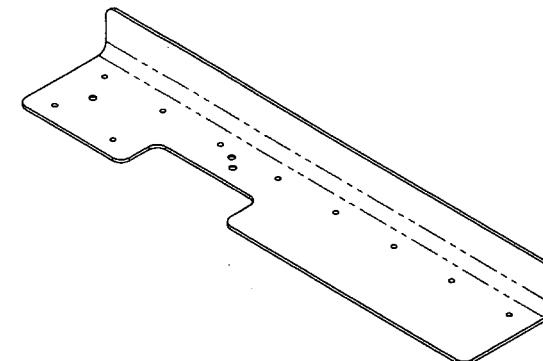
NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-1	REF JCA-M47-2-19



D4004-1 SIDE RESTRAINT

- NOTES:
- 1) MATERIAL: MADE FROM D4004-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.18 lbs



RELEASED
2010-05-05
MD

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4004
MFG. APPR.		REV. A
APPROVED		SHEET 3 OF 11
DE APPR.		TITLE SIDE RESTRAINT
DATE	10.02.10	SCALE NTS

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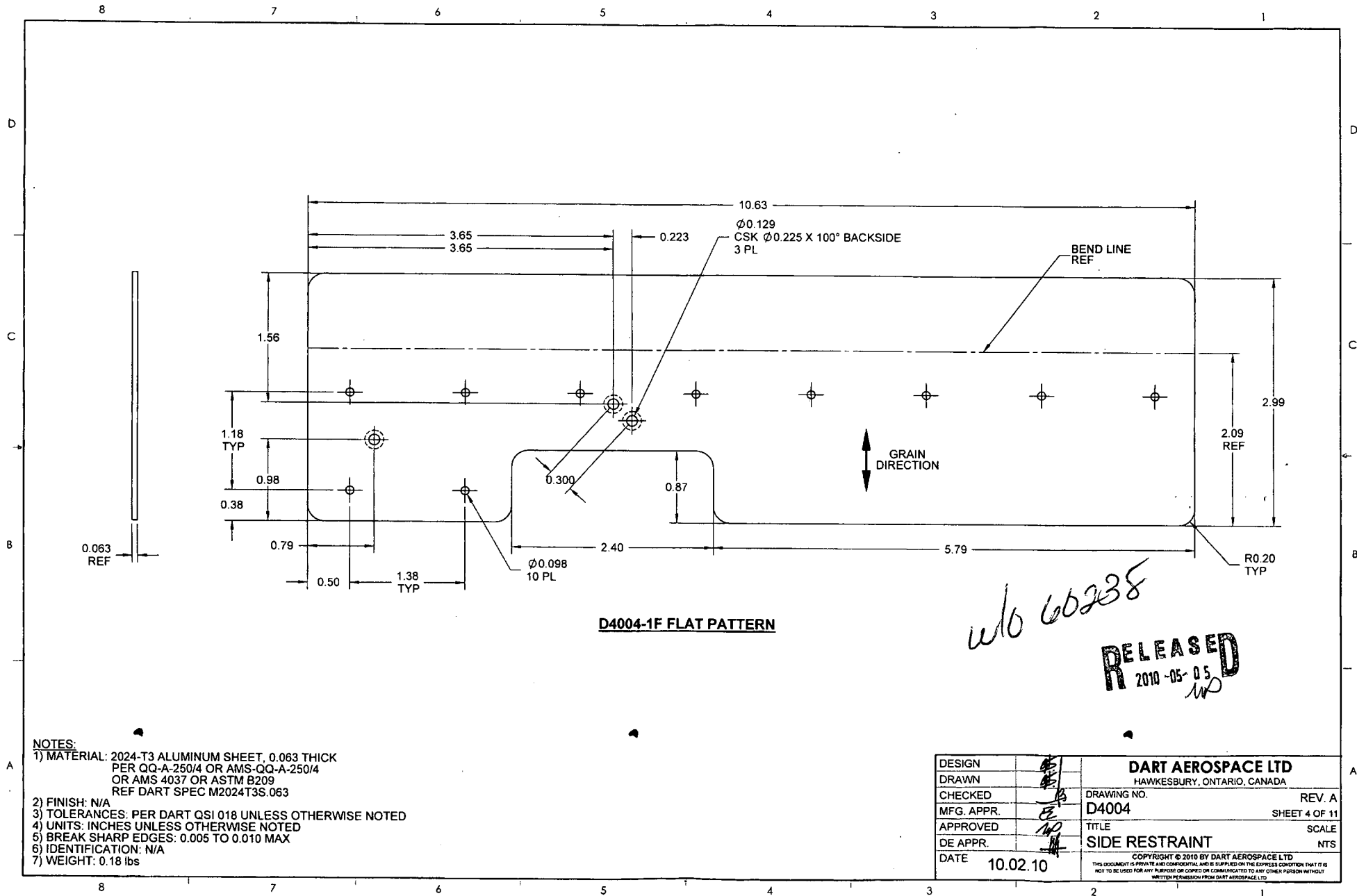
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

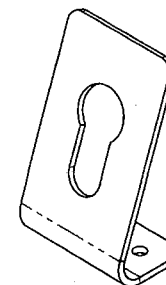
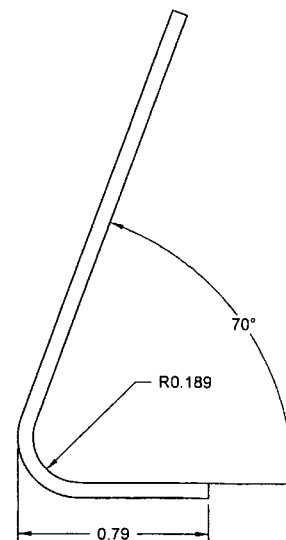
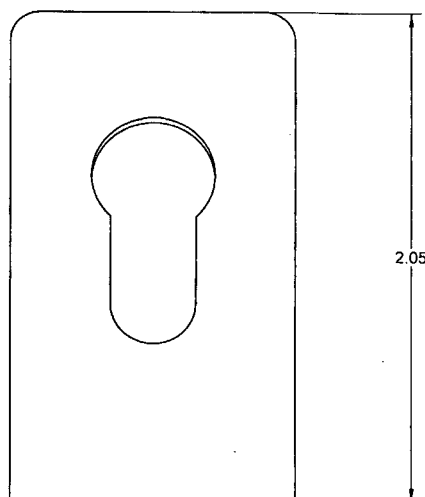
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-3	REF JCA-M47-2-19



D4004-3 STRUT LOCK BRACKET

wb 60238

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4004-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>AE</i>	DART AEROSPACE LTD	
DRAWN	<i>AE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BE</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>BE</i>	D4004	SHEET 5 OF 11
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	SIDE RESTRAINT	NTS
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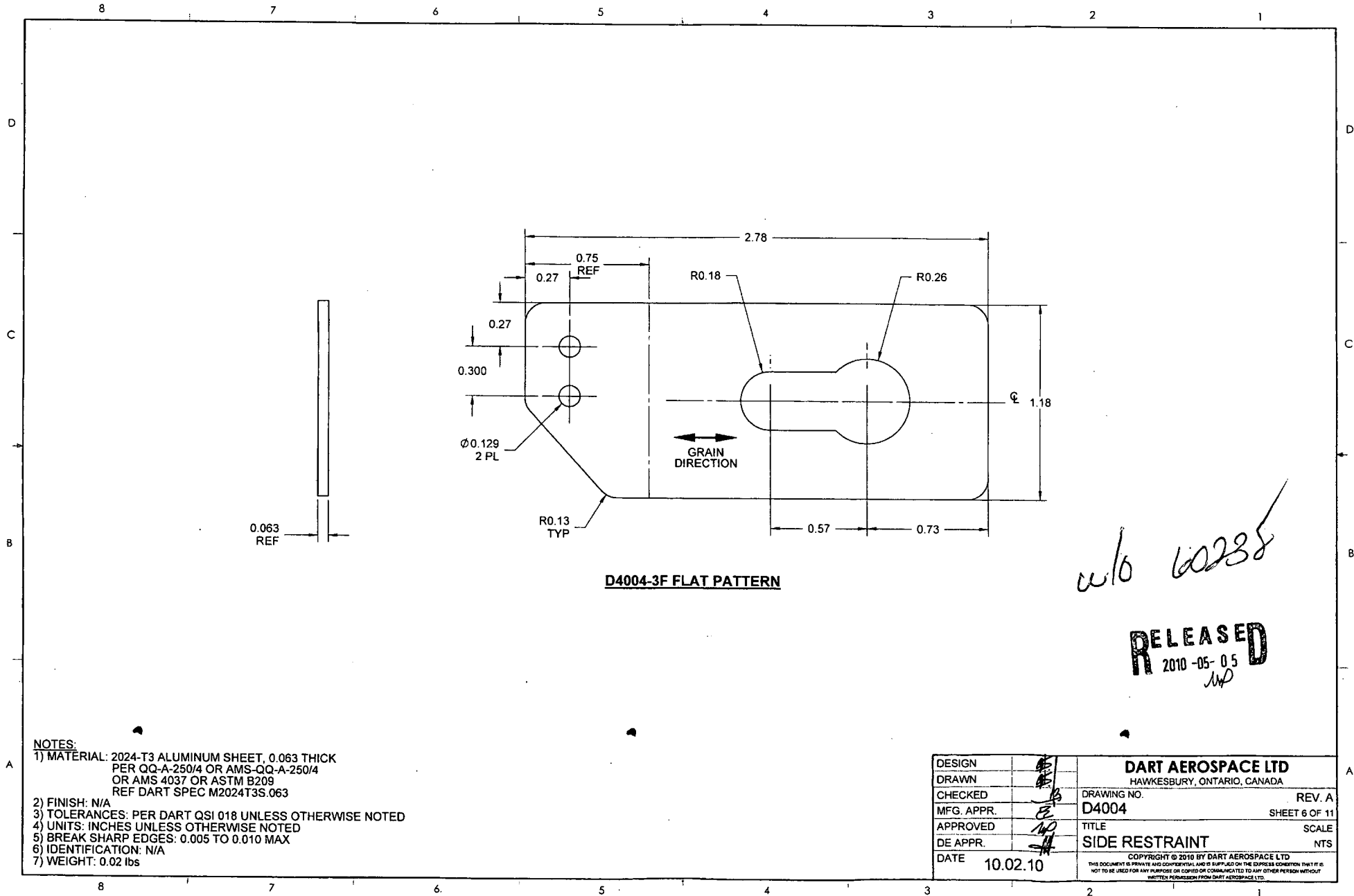
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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

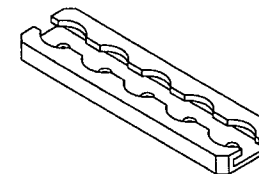
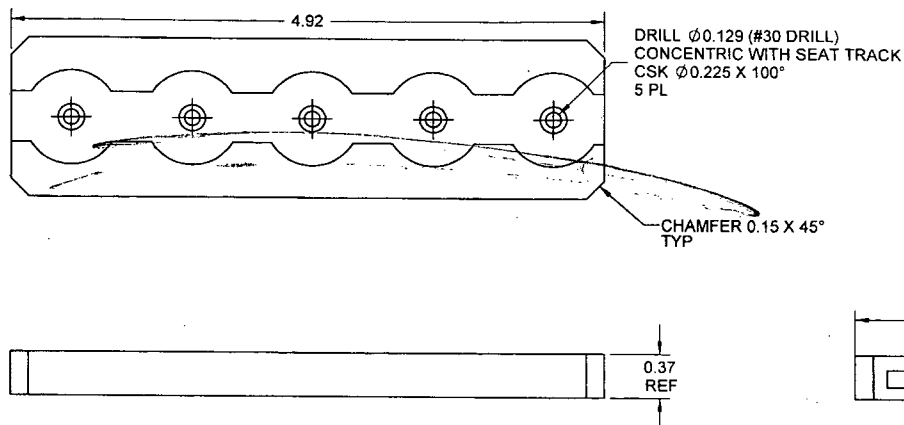
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-5	JCA-M47-2-23



D4004-5 BOTTOM STRAP ATTACH BRACKET

w/o 40235

RELEASED
2010-05-05
W

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144 OR BROWNLIN P/N 20276-144-0-0 OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4004	REV. A
MFG. APPR.			SHEET 7 OF 11
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DE APPR.			NTS
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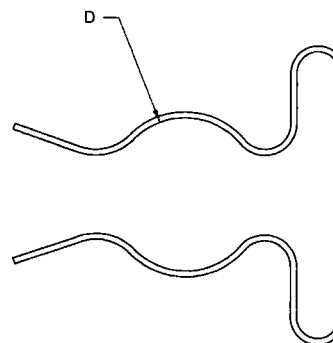
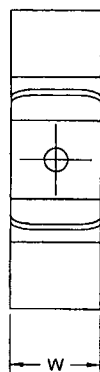
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-7	N3 REF JCA-M47-2-19

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS TUBE Ø "D"	WIDTH "W"
D4004-7	MCMASTER-CARR	1722A42	NICKEL PLATED STEEL	0.31 - 0.75	0.38

D4004-X HOSE CLIP

W/C 60238

RELEASED
2010-05-05
MP

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.01 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO. D4004	REV. A
MFG. APPR.	<i>JS</i>	SHEET 8 OF 11	
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	SIDE RESTRAINT	NTS
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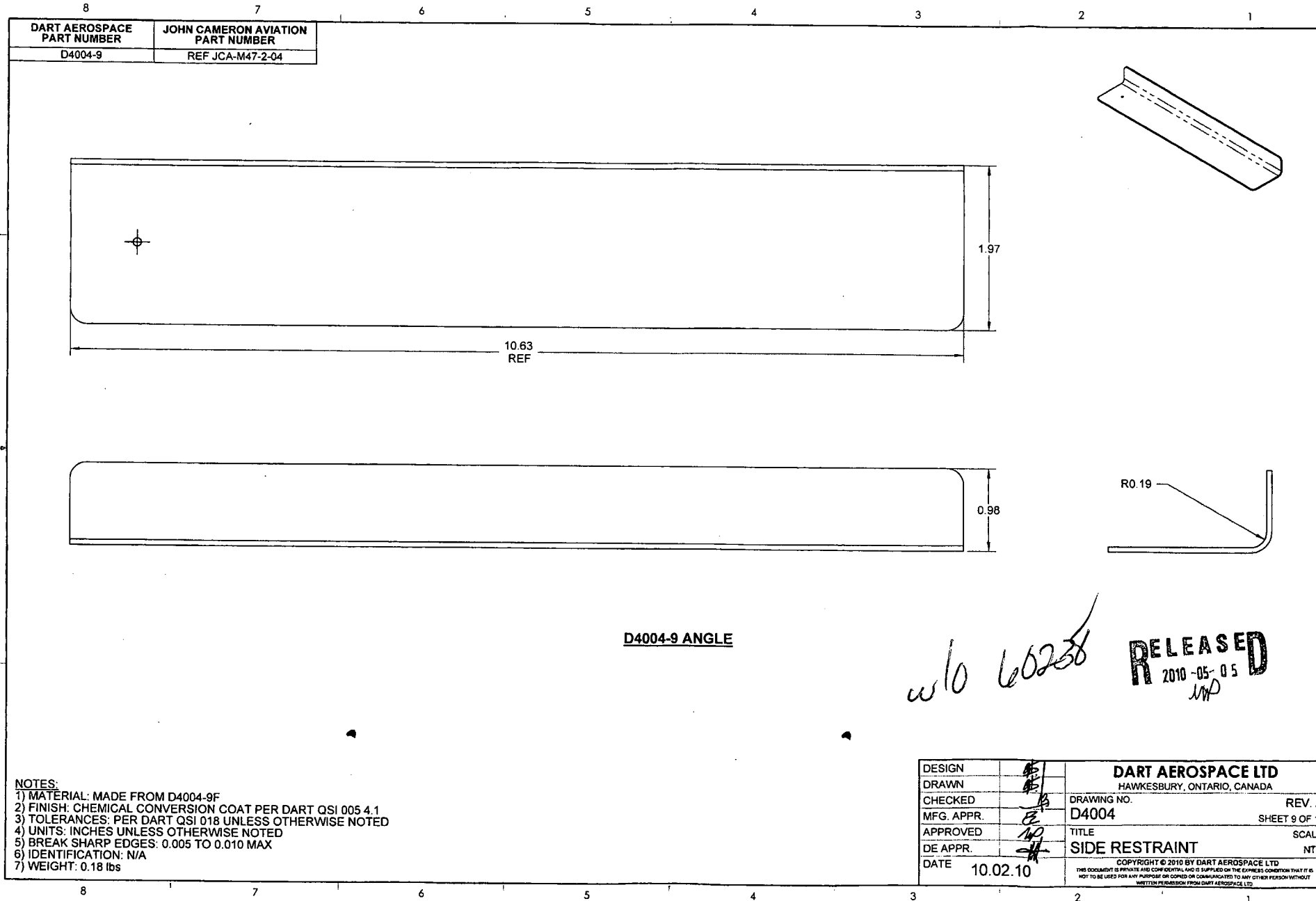
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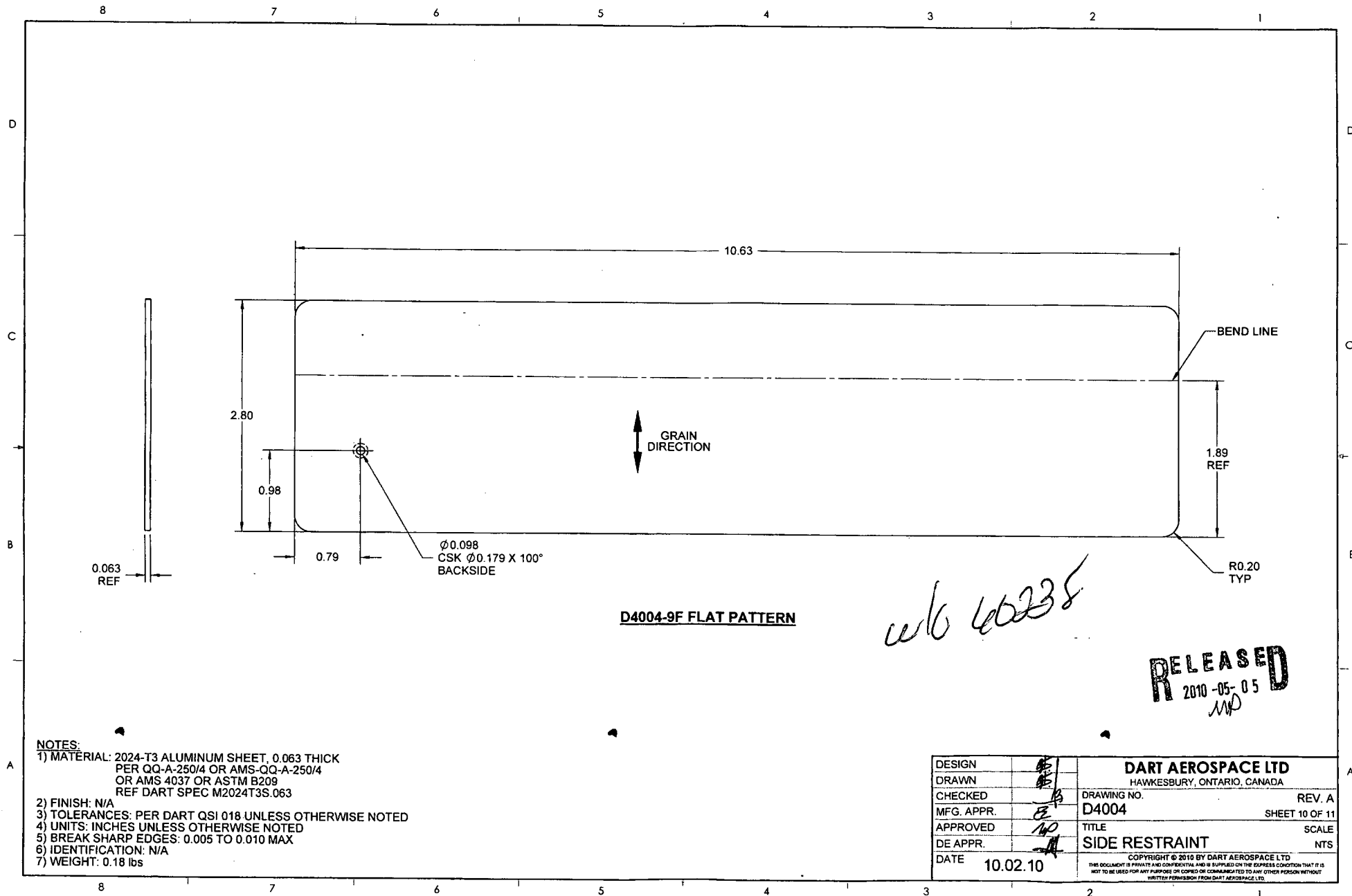
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

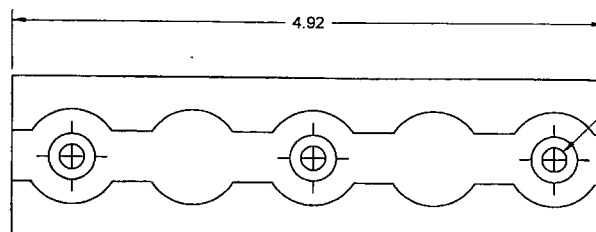
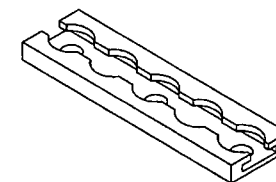
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

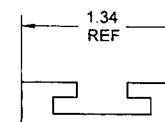
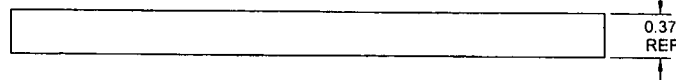
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-11	JCA-M47-2-11



DRILL $\varnothing 0.204$ (#6 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.385 \times 100^\circ$
3 PL



D4004-11 TOP STRAP ATTACH BRACKET

W6 66238

RELEASED
2010-05-05
MM

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLIN P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4004	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SIDE RESTRAINT	NTS
DATE	10.02.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries